

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011430**Date Inspected:** 23-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Chen Xi & Mr. Liufa Wen	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	Orthotropic Box Girder (OBG)	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Bay 2

This QA inspector observed ZPMC qualified welding personnel identified as 045209 perform Flux Cored Arc Welding (FCAW) welding on Longitudinal Diaphragm weld joint identified as LD 3022-001-006 & 007. ZPMC QC is identified as Mr. Yuan Qing Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

Bay 3

This QA inspector observed ZPMC qualified welding personnel identified as 044824 perform FCAW welding on Corner Assembly weld joint identified as CA3003-07/08 & 11-14. ZPMC QC is identified as Mr. Guo Yuan Ting. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA inspector observed ZPMC qualified welding personnel identified as 044824 perform FCAW welding on Corner Assembly weld joint identified as CA6501-037 & 038. ZPMC QC is identified as Mr. Guo Yuan Ting. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U4c-F.

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Bay 5

This QA inspector observed ZPMC qualified welding personnel identified as 250353 perform FCAW welding on Traveler Rail, weld joint identified as 10TR5-001-014. ZPMC QC is identified as Mr. Zhong Chong Biao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 066734 perform FCAW welding on, Bike Path, weld joint identified as BK001-046-003. ZPMC QC is identified as Mr. Wang Liang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

This QA inspector observed ZPMC qualified welding personnel identified as 067275 perform FCAW welding on, Bike Path, weld joint identified as BK001-044-003. ZPMC QC is identified as Mr. Wang Liang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

Magnetic Particle Testing (MT) - Document No's: 004918 & 004919

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. FB3073-001-001-006
2. FB3007-001-001-006
3. NDL-SA658-77m-1-12-1a/b
4. NDL-SA658-77m-14-16-1a/b
5. NDL-SA658-65m-1-13-1a/b

OBG CROSS BEAM CB16

This QA inspector observed ZPMC personnel appears to have performed base metal weld repairs on material designated as SPCM on the approved shop drawings without the Engineers approval. The areas being repaired were damaged while removing temporary lifting lug welds at the corners of this crossbeam. The component is identified as OBG crossbeam CB16. The SPCM panels affected are identified as side panel SP202A and bottom panel BP204A. AWS D1.5 2002 section 3.3.7.3 specifies "Tack welds not incorporated into the final weld shall be removed in such a manner that the base metal is not nicked or undercut. Repair of base metal accidentally removed shall be approved by the Engineer prior to making the repair. This QA informed ZPMC QA identified as Mr. Zheng Zhi Wei and ABF QA inspector identified as Mr. Wang Wen Bin of this issue and that an incident report would be generated. See attached photo.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer
